

Work Order ID 73347

Wednesday, August 31, 2011 11:07:03 AM



Page 1

Item ID: D2855

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 9/1/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: mf Date: 11-09-01 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2855

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14808 ☐ Cast per Dwg D2855 ☐ Material Release Note
Required

CL 11/09/01 50

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

Rec'd 11/9/08 (50)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 works

count
(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Drill as per Dwg D2855 using DT8235 □ 2- Open holes to 19/64" □ 3- Deburr

SB 11/10/04

50

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 - 11 - 04 50

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____ □ OVEN TEMPERATURE:

□ FINISH TIME: _____

10:15

10:45

3200F

50X4 M-L 11/11/16

M118439

W/O:		WORK ORDER CHANGES					
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Page 3

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Item Name: Cap

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Start Date: 9/1/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				50	BR 11-11-16,		
170 Small Fab Small Fab	Small Fab Memo Install Inserts as per Dwg D2855	0.00 0.00				50	BR 11-11-17		
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				50	BR 11-11-17		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: FP.2

0.00



Packaging

Memo

0.00

Packaging

50 11-11-17

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/21 JD

11-11-17
50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 11:07:00 AM

Page 1

Work Order ID: 73347

Parent Item: D2855

Parent Item Name: Cap



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B00.06.22 Added receiving step & removed P/O for powder coat
EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			100	Each	1,460.000	2	100			

INSERT

ALS4-1032-225.

Location

118966.

Loc Qty

Loc Code

100 AL 11-11-17.

ST282

1460

100896

200

111529

64

111581

196

118520

1000

D2855P

Purchased

No

170

Each

0.0000

1

50



Cap



PO 11/9/28 (50)

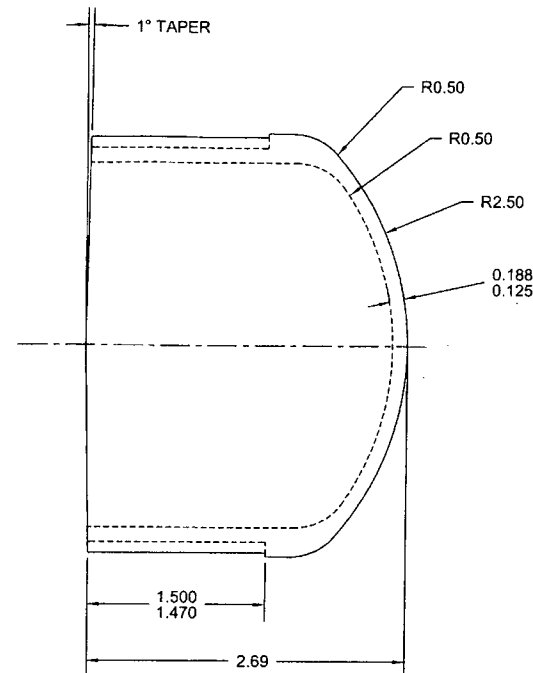
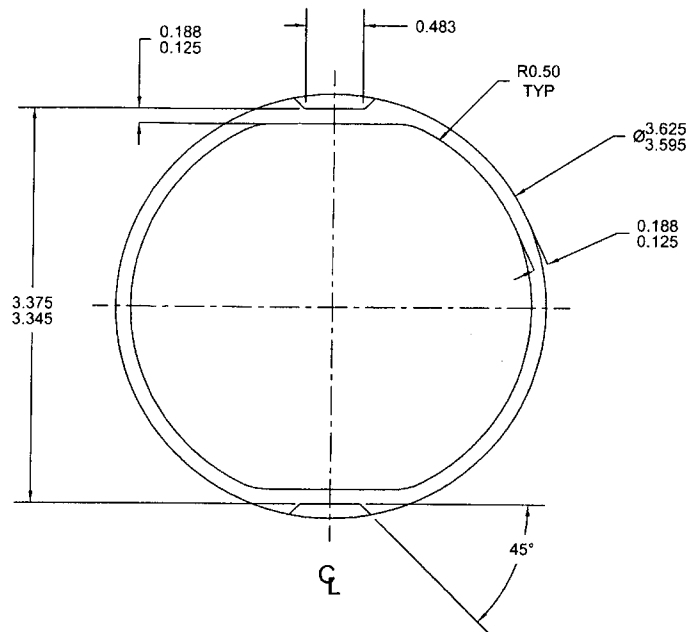
W/O:		WORK ORDER CHANGES					
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D2855C CASTING DETAIL



NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

73347 RELEASED
09/27/15 MB

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

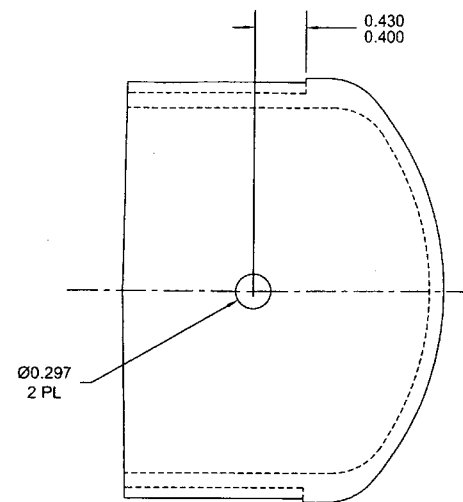
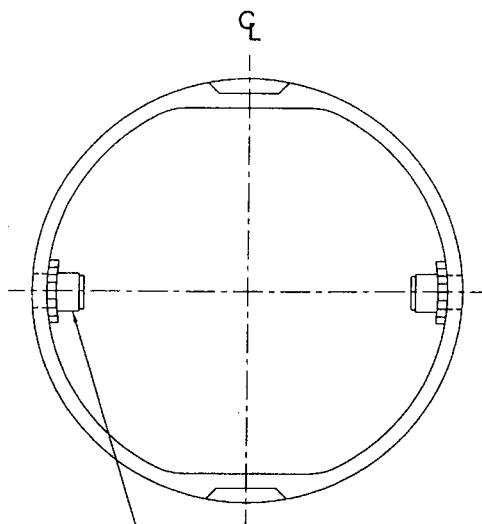
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP
(MAKE FROM D2855C CASTING)

#73347

RELEASED
21/11/15

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

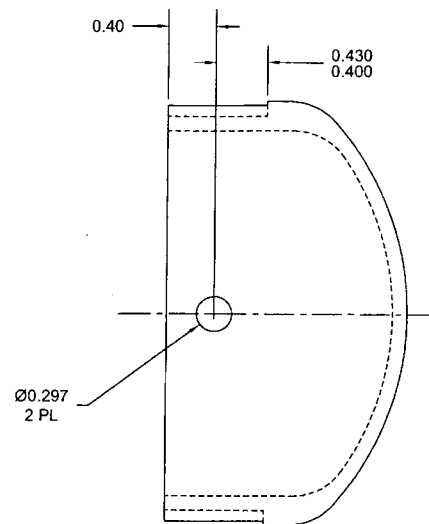
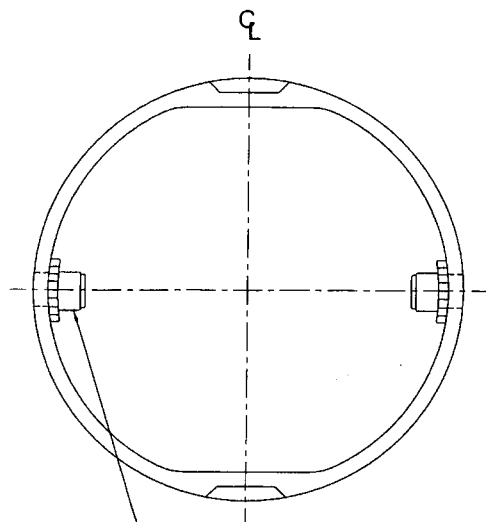
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL





D2855-3 CAP 
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POKER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

#73347

RELEASED
2017/5/13

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14808

Purchase Order Date 9/1/2011

PO Print Date 9/1/2011

Page Number 1 of 1

Order From : VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA

Contact Name

Vendor Phone

514 683 9777

Vendor Fax

514 683 0375

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL 11/09/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2855P	Cap	9/16/2011 Yes	50.00 Each	FedEx PI collect	\$18.1000	\$905.00

Special Inst: AS PER DWG D2855 REV. A
B73347

PO Total:

\$905.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 9/1/2011

CL
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

*Att. Chantal*7CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCEFONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD2225 CHEMIN ST. FRANCOIS, DORVAL, QC H9P-1k3
TEL : (514) 683-9777 FAX: (514) 683-0375Expédié à
Shipped**DART AEROSPACE**

A.F. & P.W.Série no./Serial no.

1270 Aberdeen StreetPacking
Date: **27/09/2011** Slip No. **33821****Hawksbury, ON, K6A 1K7**Vôtre No. Commande **14808**
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificates di détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
50	D 2855 CAP <i>Suloy/29</i>	Z098046	A356.2	ingot#C626-1625 B# 1126501

Analyse
Analysis (as in Ingot)

(Si)	7.2%	(Al)	balance
(Fe)	0.10%		
(Cu)	<0.01%		
(Mn)	0.02%		
(Mg)	0.41%		
(Zn)	<0.01%		
(Ti)	0.13%		

Donne
Yield :Résistance a la tension :
Tensile Strength :Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTDDept/Dep :
Par/Per :

Coc-100

Aluminum Foundry Ltd

2225 Chemin St. Francois
Dorval, Québec H9P 1K3
Tel: (514) 683-9777
Fax: (514) 683-0375
email: info@foundryafpw.com

Packing Slip

Packing Slip No.: 33821
Shipped Date: 26 09 2011

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-5200 Fax (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 14808	
Shipped By:	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	50
<div>Received by:</div> <div>Date:</div>			
Comment:			